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[54] **PROCESS FOR THE PREPARATION OF AIR-REFRESHING GELS AS WELL AS THE OBTAINED GELS**

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[58] Field of Search **252/522 A**

[56] **References Cited**

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Derwent Abstract of Japanese Application 52/070,035, 6/10/77.

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[57] **ABSTRACT**

Aqueous air-freshener gels having an increased content of perfume are prepared by homogeneously mixing the perfume with one or more solid inorganic carriers selected from the group consisting of magnesium, oxide powder, active carbon, zeolites and absorption agents based on silica and then combining the homogeneous mixture obtained in this way with an aqueous gel or the gel forming components. In the case of absorption agents based on silica or zeolites the further use of a non-ionogenic emulsifier is required.

5 Claims, No Drawings

**PROCESS FOR THE PREPARATION OF
AIR-REFRESHING GELS AS WELL AS THE
OBTAINED GELS**

The invention relates to a process for the preparation of air-freshener gels.

Air-freshener gels are popular consumer products. They consist of a perfume containing carrier material, from which the perfume evaporates slowly and thus gives a pleasant smell to the atmosphere. The life time and the amount of perfume emitted per time unit are determined mainly by the amount of perfume in the air-freshener. In many known types of air-fresheners gelled water is used as carrier material. Because per-
fumes are generally not or hardly soluble in water they should be dispersed therein as homogeneously as possible. Furthermore gelled organic solvents like monohy-
dric or polyhydric alcohols or glycol ethers are used as carrier materials. However, water has the advantage of
being cheap and toxicologically unsuspected.

Aqueous gels may be prepared in many ways known as such using as gelling agent e.g.: vegetable gums like carrageenin, agar agar, alginates, pectine, guar gum, tragacanth, karaya gun, xanthan etc. and further for instance gelatin as well as starch and cellulose deriva-
tives. In some cases the gel strength can be increased by the addition of salts of bivalent or polyvalent metals like Ca, Mg, Al or Cr. Furthermore synthetic polymers like
polyvinyl alcohol may be used as gelling agent.

Such aqueous gels have the disadvantage that they only may contain a limited amount of perfume. In the literature mostly a maximum perfume content of about 10% is mentioned but in practice it appears that a per-
fume content of more than about 6% strongly reduces the gel strength and/or causes syneresis whereby the perfume leaves the gel as a liquid. Aqueous perfume
gels are described for instance in the published Japanese patent applications No. 54,110,990 (gelling agent: carra-
gheenin and sodium stearate, perfume content up to 6%); No. 53,088,334 (gelling agent: bacterial polysac-
charide, 1-10% of perfume); and No. 52,136,893 (gel-
ling agent: carrageenin and polyvinyl alcohol, 2-4%
of perfume), and in the French patent application No. 2,293,976 (gelling agent: carboxymethyl cellulose/Al-
salt, 5% of perfume).

Furthermore Dutch patent application No. 76,11041 also discloses the use of carboxymethyl cellulose and salts of trivalent metals as gelling agents in aqueous
perfume gels. Although it is mentioned in the specifica-
tion that these gels may contain up to 20% of perfume the examples only illustrate a perfume content of 4%.
Likewise Dutch patent application No. 76,02254 dis-
closes similar aqueous perfume gels which would con-
tain up to 10% of perfume whereas in the examples only
gels are illustrated containing up to 2.5% of perfume.
Dutch patent application No. 75,02596 describes aque-
ous gels based on mixtures of carrageenin and locust
bean gum which according to the specification may also
contain up to 10% of perfume, however, from the ex-
amples it appears that no more than 3.3% of perfume is
used.

Dutch patent application No. 76,12909 discloses gels based on amylose as gelling agent. In the specification it
is indicated that the perfume content of these gels is
0.25-30% preferably 0.5-5%. It is true that one of the
examples discloses a gel containing 30% of perfume,
however, for that result a content of 10% of pure (and

therefore expensive) amylose is required. When starch containing 70% of amylose is used no stable gel can be produced yet with even 10% of perfume. Furthermore these gels have the disadvantage that for the prepara-
tion of the necessary amylose-solution high tempera-
tures (up to 170° C.) and pressures (up to 7 atm) are required and therefore relatively complicated equip-
ment.

In some of the above mentioned patent applications it is mentioned that preferably the perfume is used to-
gether with an amount of emulsifier for promoting the homogeneous distribution of the perfume in the aqueous phase. In Japanese patent application No. 52,070,035 it is stated that aqueous gels cannot contain more than
2-3% of perfume unless a non-ionogenic emulsifier is added in a amount of 0.5-1.5 times the amount of per-
fume, in which case the perfume content of the gel may rise to 10%. Anyway the amount of perfume which can
be distributed homogeneously in an aqueous gel highly depends on the solubility of the perfume in water and
thus on the type of the components composing the perfume.

The phrase "perfume" is used to mean a mixture of organic compounds like aldehydes, ketones, nitriles, esters, carboxylic acids, alcohols, ethers etc. which may also contain natural products like essential oils, resi-
noids, balsams, concrètes etc. This mixture is meant to emit a desired smell. In many cases a perfume contains
a mostly small amount of a solvent or diluent usual in perfumery, for instance because one or more of the
components used in the composition are only available or manageable in solution.

The purpose of the invention is to provide aqueous air-freshener gels having an increased perfume content and for that reason a longer lifetime and/or a higher
perfume emission per time unit. The phrase "increased perfume content" means in this respect a content of at
least 5% and preferably more than 10% based on the total weight of the gel.

It has been found that such air-freshener gels can be prepared by previously mixing the perfume with spe-
cific solid inorganic carrier materials and then introduc-
ing this mixture, which hereinafter will be called "pre-
mix" in an aqueous gel. As specific solid inorganic car-
rier materials are mentioned: magnesium oxide powder, active carbon, zeolites and absorption agents based on
silicon dioxide (silica) like many kinds of silica gel, bentonite and especially hydrophobic or non-hydro-
phobic pyrogenic silica. Furthermore mixtures consist-
ing of solid materials can be used as far as they mainly consist of one or more of the above mentioned types of
carrier materials.

In Dutch patent application No. 76,11041 it is men-
tioned that for the preparation of the aqueous gels de-
scribed therein considerable amounts of fillers can be
used such as graphite, carbon, carbon black, silicates
and several kinds of silica. However, no special process
for the preparation of aqueous gels is indicated therein
nor it is mentioned therein that these fillers should meet
specific requirements. Furthermore it is not indicated
either that by addition of these fillers the gels could
contain more perfume. This last aspect is even improba-
ble because the addition of fillers will decrease the
amount of aqueous perfume dispersion per weight unit
of gel and for that reason the perfume content. There-
fore the mentioned prolongation of the perfume emis-
sion should be ascribed to retarded evaporation. How-
ever, this has the disadvantage that more gel or a larger

evaporating surface is required for obtaining sufficient perfume emission per time unit.

Surprisingly the process according to the invention whereby the perfume is absorbed previously on one or more of the above mentioned inorganic carrier materials offers the opportunity to introduce much larger amounts of perfume in aqueous gels than was usual up to now.

The aqueous gels according to the invention can be prepared by using gelling agents known and usual for aqueous gels as for instance described in the already mentioned patent specifications and patent applications and the literature cited therein. As already mentioned before, very suitable gelling agents are for instance agar agar, carrageenin and modified cellulose like methyl cellulose, hydroxyethyl cellulose and carboxymethyl cellulose. Some gelling agents may advantageously be combined with a salt of a polyvalent metal as crosslinking agent. Part of the water used for preparing the gel can optionally be replaced by water miscible organic solvents like monohydric or polyhydric alcohols for instance ethanol, isopropanol, ethylene glycol etc. as far as these solvents do not affect the activity of the gelling agent. For economic reasons this replacement is generally not recommended because organic solvents are more expensive than water.

The amount of perfume which is present in the air-freshener gel according to the invention is determined, on the one hand, by the amount of perfume in the premix and, on the other hand, by the amount of premix in the gel. This last amount is not subjected to any fundamental restriction but in practice is restricted by the fact that on preparing the gel mixture the viscosity increases with an increasing amount of premix. Therefore the maximum amount of premix to be used is determined by the demands made by the processing of the gel mixture during and after the preparation and the equipment which is available for the preparation. When the demand is made that the mixture directly after the preparation should be so liquid that it simply can be poured into molds, the maximum amount of the premix in the gel is about 35%. However, when for the preparation heavy duty stirring equipment is used and the gel packings are filled by means of equipment and operations under pressure, considerably higher premix contents are achievable.

The maximum perfume content in the premix is determined by the requirement that the premix should be a solid mixture which optionally may be lumpy and feeling moist. To meet this requirement the minimum amount of solid carrier material in the premix depends on the type of carrier material. It varies from about 60% for bentonite to about 10% for some highly porous kinds of pyrogenic silica. For active carbon and magnesium oxide the minimum contents are about 40% and about 30% respectively.

When using active carbon or magnesium oxide as solid carrier material the addition of emulsifiers is not recommended because this affects the stability of the gels according to the invention. On the contrary, by using a zeolite or a carrier material based on silica it is necessary to previously mix the perfume homogeneously with a non-ionogenic emulsifier in an amount of 5-200%, calculated on the weight of the perfume. Preferably emulsifiers having a HLB-value of 9 or more are used such as esters of fatty acids and polyethylene glycols and condensation products of alkylphenols or fatty alcohols with ethylene oxide.

An air-freshener gel preparable with simple means and containing at most 35% of premix will therefore regard to the above mentioned requirements generally have a composition mentioned in the following table:

		preferably
inorganic carrier material	0.5-30%	1.5-25%
perfume	5-30%	10-25%
emulsifier (only in the case of silica or zeolite)	0.5-20%	1-5%
water (optionally partly replaced by a water miscible organic solvent)	50-93% maximum	87%
gelling agent	0.5-10%	
polyvalent metal salt	0-5%	
preservative	0-1%	
dye	0.1%	

The gel is prepared according to methods known per se for such products, except that the process of the invention differs from these methods in that the perfume is previously mixed with the solid carrier material according to the invention into a homogeneous mixture called premix. If the carrier material is a zeolite or a carrier material based on silica the perfume is stirred homogeneously with a non-ionogenic emulsifier before said mixing stage. The ready premix is then mixed with the water, the gelling agent and optionally the metal salt, the preservative and the dye. Preferably water and gelling agent are mixed previously and then the premix is added as soon as possible. Some gel mixtures are preferably prepared at elevated temperatures and then at these temperatures poured into molds. After cooling to room temperature the gel mixture solidifies. However, other gel types can be prepared at room temperature and remain liquid for a sufficiently long time to be poured into molds. All these and similar methods can be used for the preparation of the gels according to the invention. An example of a perfume that can be used in the gels according to the invention was prepared according to the following recipe:

300 parts by weight of bornyl acetate
200 parts by weight of orange oil Florida
140 parts by weight of β -phenylethanol
100 parts by weight of geraniol
100 parts by weight of α -pentyl-cinnamaldehyde
75 parts by weight of benzyl acetate
50 parts by weight of dihydromyrcenol
30 parts by weight of 2,4-dimethyl-3-cyclohexene-carbaldehyde
5 parts by weight of decanal
1000 parts by weight

The examples are only intended as illustration of the process according to the invention. The invention is not restricted thereto:

EXAMPLE I

15 g of perfume according to the above mentioned recipe and 2 g of Arlypon NP-14⁽¹⁾ were mixed and stirred homogeneously. Then 5 g of Aerosil⁽²⁾ was added and the product was mixed until an almost dry homogeneous powder was obtained. The so prepared 22 g of premix was homogeneously dispersed in 20 g of water while heating to about 75° C. 2.3 g Carrageenin, 0.2 g of chloroacetamide and 0.5 g of CaCl₂·2H₂O were dissolved in 55 g of water while heating to about 75° C. This somewhat viscous solution was added to the above

described dispersion of premix in water. The total mixture was stirred completely homogeneous and poured into molds while warm. After cooling to room temperature firm and stable air freshener gels were obtained having a perfume content of 15%.

⁽¹⁾Arlypon NP-14 is a non-ionogenic emulsifier, marketed by Chemische Werke Grünau, Illertissen, West-Germany.

⁽²⁾Aerosil is a pyrogenic silica, marketed by Degussa, Hanau, West-Germany.

EXAMPLE II

According to the method described in Example I 31.5 g of a somewhat moist feeling but solid premix was obtained from 25 g of the above mentioned perfume, 2.5 g of Arlypon NP-14 and 4 g of Aerosil. 45 g of aqueous dispersion was obtained by addition of water. 2.3 g of carrageenin, 2 g of chloroacetamide and 0.5 g of CaCl₂·2H₂O were dissolved at 75° C. in 52 g of water. The warm premix dispersion and carrageenin solution were mixed, stirred homogeneous and discharged into molds. After cooling to room temperature firm and stable air-freshener gels were obtained having a perfume content of 25%.

EXAMPLE III

According to Example I a premix was prepared from 20 g of perfume, 2 g of Arlypon NP-14 and 5 g of Aerosil. A gel solution was prepared by dissolving 4 g of agar agar in 62.8 g of boiling water. After cooling to about 70° C. 5 g of ethanol, 1 g of propylene glycol and 0.2 g of a 35% formaldehyde solution were added. Finally the above described premix was added, the mixture stirred homogeneous and poured into molds while warm. The air-freshener gels obtained after cooling had a perfume content of 20%.

EXAMPLE IV

A premix was prepared by thoroughly mixing of 19 g of perfume with 11 g of magnesium oxide powder. A gel solution was prepared by dissolving 0.5 g of CaCl₂·2H₂O, 0.2 g of a 10% solution of 5-bromo-5-nitro-1,3-dioxane in propylene glycol (preservative) and 2.6 g of carrageenin in 66.7 g of water at 85° C. After the complete mixture was stirred homogeneous, the above described premix was added, the mixture was stirred homogeneous again and poured into molds while

warm. The air-freshener gels obtained after cooling had a perfume content of 19%.

EXAMPLE V

The process of Example IV was repeated but now with a premix consisting of 15 g of perfume and 15 g of active carbon. The air-freshener gels obtained had a perfume content of 15%.

I claim:

1. A process for the preparation of aqueous air-freshener gels containing a perfume characterized by homogeneously mixing the perfume with one or more solid inorganic carrier materials selected from the group consisting of magnesium oxide powder, active carbon, zeolites and absorption agents based on silica and then combining the homogeneous mixture obtained in this way with an aqueous gel or the gel forming components, said perfume having been previously mixed homogeneously with a non-ionogenic emulsifier in an amount of 5-200% calculated on the weight of the perfume, when zeolites or absorption agents based on silica are used.

2. The process according to claim 1, characterized by using silica gel, bentonite, and/or hydrophobic or non-hydrophobic pyrogenic silica as absorption agents based on silica.

3. The process according to claim 1, characterized by using an emulsifier having a HLB-value of at least 9 as the non-ionogenic emulsifier.

4. The process according to claim 1, characterized by preparing an air-freshener gel consisting of:

inorganic carrier material as indicated in claim 1	0.5-30% by weight
perfume	5-30% by weight
emulsifier (only in the case of carriers based on silica or zeolites)	0.5-20% by weight
water (optionally partly replaced by a water miscible organic solvent)	50-93% by weight
gelling agent	0.5-10% by weight
polyvalent metal salt	0-5% by weight
preservative	0-1% by weight
dye	0.1% by weight

5. Air-freshener gels obtained by applying the process according to claim 1.

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